

Work Order ID 140460-2

January 04, 2016 3:23:34 PM

140460

Page 1

Item ID: D3319-3

Revision ID:

Item Name: Full Length Wearplate

Start Date: 1/4/2016 Start Qty: 12.00

Required Date: 1/18/2016 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: SA Date: 20160105 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3319	C								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.04							
FLOW CNC Waterjet	1-Cut as per Dwg D3319 Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

(20) _____ 01/05/16

(20) _____ 01/05/16

Please cut Jan 6-8.

Accept
4
12 20
12 20

Work Order ID 140460

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Page 2

Item ID: D3319-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Full Length Wearplate

Start Date: 1/4/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 1/18/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(20)

DAS
38
9-89
JAN 13 2016

140

NC BRAKE

0.00

140

Brake NC

Memo

0.01

Brake NC

Form using DT8326 & DT8261 as per Dwg D3319Rev: C

DAS
30
9-89

20

JAN 14 2016

150

QC6- Inspect dimensions to drawing

0.00

150

QC

Memo

0.00

Quality Control

(20)

DAS
38
9-89

JAN 15 2016

Work Order ID 140460

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Page 3

Item ID: D3319-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Full Length Wearplate
 Start Date: 1/4/2016 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 1/18/2016 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Large Fab Large Fab	Weld per dwg A/R Hardcoat steel Batch: <i>m130661</i> Large Fab Memo Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Batch A/R 7560 Hardcoat Rod <i>m130661</i>	0.00 0.06				<i>4</i>	<i>22</i>	<i>16-01-15</i>	
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				<i>(4)</i>			DAS 38 9-88 JAN 15 2016
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<i>(4)</i>			DAS 38 9-88 JAN 15 2016

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Page 4

Item ID: D3319-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Full Length Wearplate
 Start Date: 1/4/2016 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 1/18/2016 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>m 130746</i> Memo START TIME: <i>10:45</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>11:15</i>	0.00 0.00				<i>4</i>	<i>φ</i>	<i>16-01-19</i>	<i>33 38</i>
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>(4)</i>			<i>DAS 38 9-89</i>
210 *210* Packaging Packaging	Packaging Memo Identify on inside surface using a permanent fine point marker with the following:TCCA-PDA, Dart Aerospace Ltd.P/N: D3319-3, B/N: BXXXXXFor Product Eligibility see PDA05-18 and Stock Location: <i>5061</i>	0.00 0.00				<i>4</i>			<i>DAS 35 3-89</i>

JAN 21 2016

JAN 21 2016

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Item ID: D3319-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Full Length Wearplate

Stop

NS2

Start Date: 1/4/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 1/18/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.02

Quality Control

JAN 21 2016

MLJ

JAN 21 2016

Picklist Print

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Page 1

Work Order ID: 140460

140460

Parent Item: D3319-3

D3319-3

Parent Item Name: Full Length Wearplate

Start Date: 1/4/2016

Required Date: 1/18/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: A05.05.12New issueKJ/JLM
IPP Rev:B Now on Waterjet 06-10-03 JLM

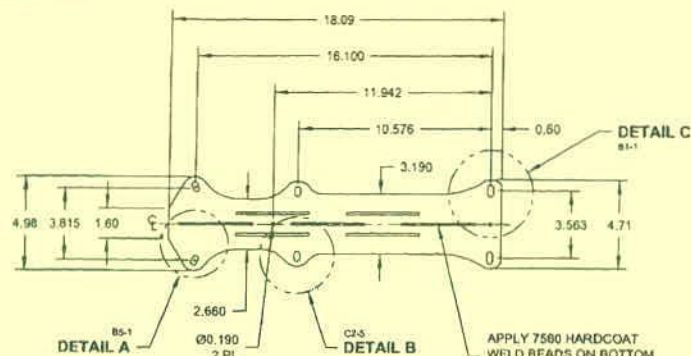
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA		Purchased	No			100	sf	112.2542	3.2524	41.08295			

M1010S18GA

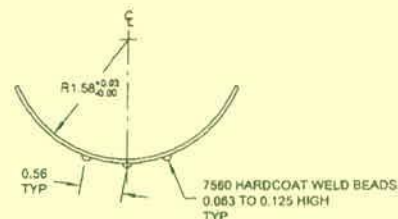
1010/1025 SHEET .048

1/18/16

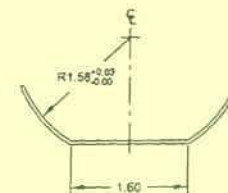
Location	Loc Qty	Loc Code
MAT019	112.254152	
124428	3	
m130454	0.3542	
m132886	33.65	
m133560	11.25	
m13390	64	



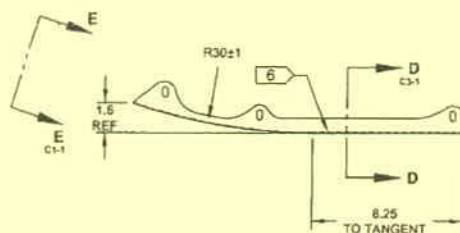
D3319-1F FLAT PATTERN



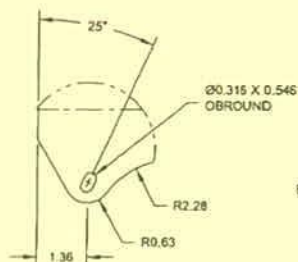
SECTION D-D
SCALE 4X



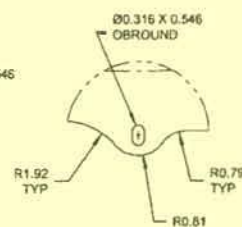
SECTION E-E
SCALE 4X



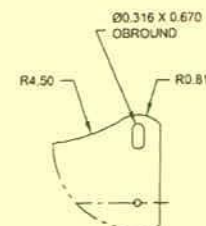
D3319-1 BENDING DETAIL
MAKE FROM D3319-1F



DETAIL A
SCALE 4X



DETAIL B
SCALE 4X



DETAIL C
SCALE 4X

D3319-1 WEARPLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A368/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.90 LBS APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

RELEASED
2012-03-16
PER ECN 12-546 12-13-16

C	UPDATE TO CURRENT STANDARDS IAW QSI 043; CLOSED AFT. MOST HOLE ON -3/-5/-7 (REF DETAIL G); SEE NCR12-547.	MB	12.03.13
B	WIDEN HOLES, REDUCE WIDTH ON -3/-5/-7	PH	05.06.06
A	NEW ISSUE	PH	04.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.03.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D3319

REV. C

SHEET 1 OF 4

TITLE

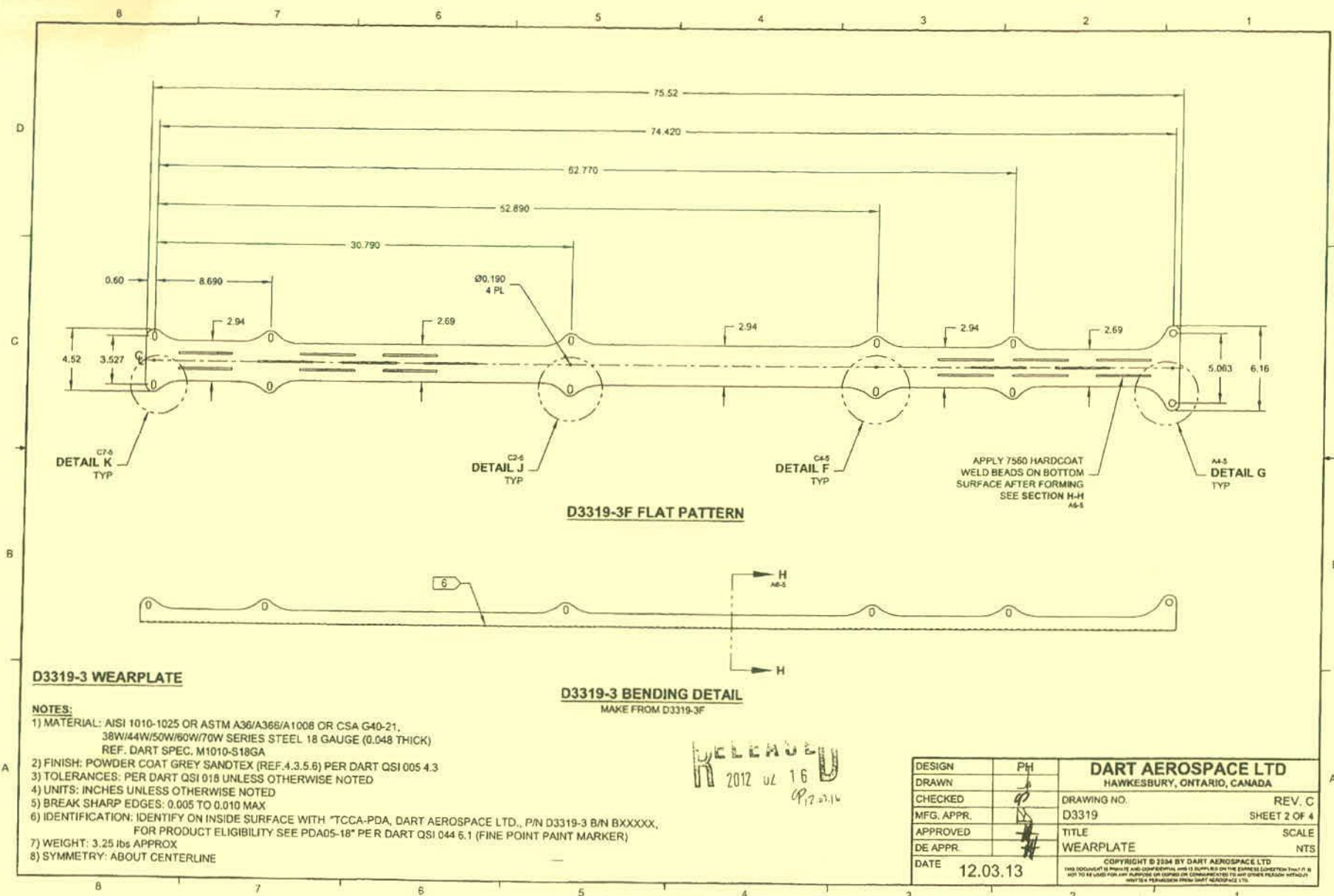
WEARPLATE

SCALE

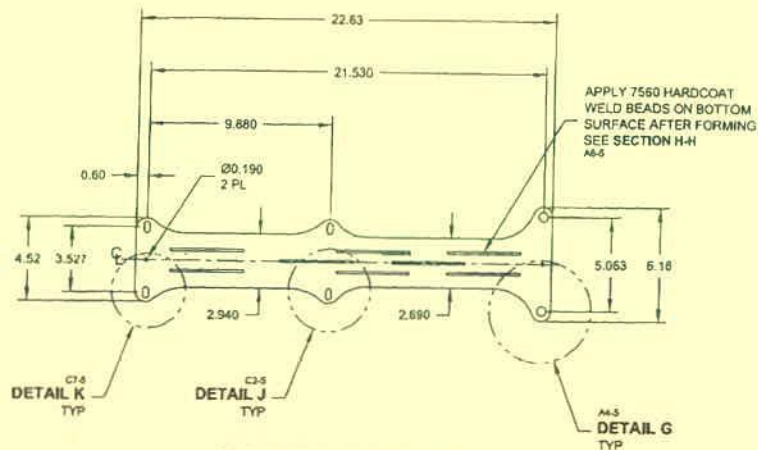
NTS

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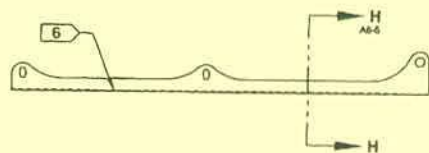
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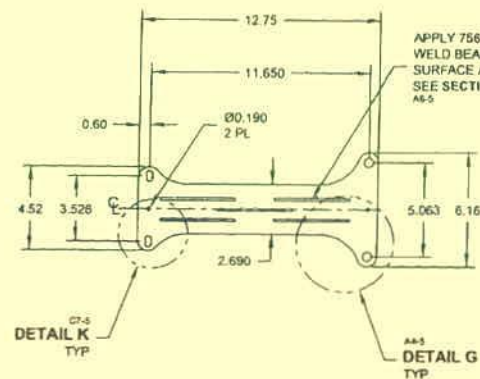
RELEASED
2012 JUL 16
0917 0214



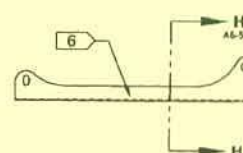
D3319-5F FLAT PATTERN



D3319-5 BENDING DETAIL
MAKE FROM D3319-5F



D3319-7F FLAT PATTERN



D3319-7 BENDING DETAIL
MAKE FROM D3319-7F

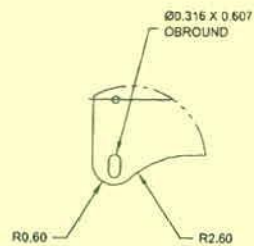
D3319-5/-7 WEARPLATE

NOTES:

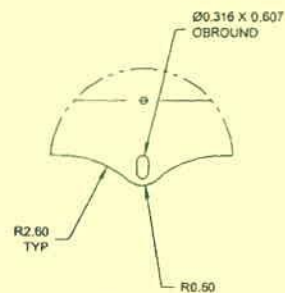
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-X B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 046 6.1 (PERMANENT MARKER)
- 7) WEIGHT: D3319-5 = 1.05 lbs APPROX; D3319-7 = 0.60 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

RELEASED
2012-02-16
Q12.5314

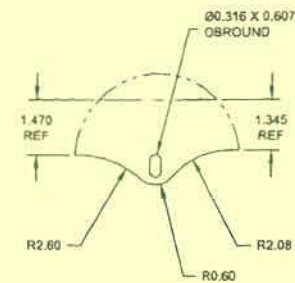
DESIGN	PH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3319	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	12.03.13	COPYRIGHT © 2004 BY DART AEROSPACE LTD	



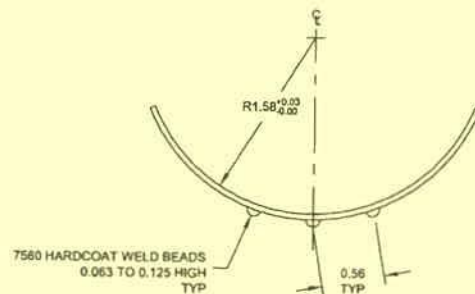
DETAIL K
SCALE 2X



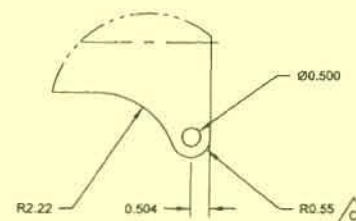
DETAIL F
SCALE 2X



DETAIL J
SCALE 2X



SECTION H-H
SCALE 4X



DETAIL G
SCALE 2X

RELEASED
2012-02-16
09.2 03.16

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3319	SHEET 4 OF 4
MFG. APPR.		TITLE	SCALE
APPROVED		WEARPLATE	NTS
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DART AEROSPACE LTD		Work Order:	140460
Description: Wearplate		Part Number:	D3319-3
Inspection Dwg: D3319	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.190	+0.005/-0.001	Ø .193	/		V-DL-02	
Ø0.500	+0.006/-0.001	Ø .505	/		Tap	
0.316	+/-0.010	.316	/			
0.607	+/-0.010	.610	/			
2.94	+/-0.030	2.945	/			
2.69	+/-0.030	2.696	/			
3.527	+/-0.010	2.521	/			
4.52	+/-0.030	4.516	/			
5.063	+/-0.010	5.058	/			
6.16	+/-0.030	6.155	/			
0.60	+/-0.030	.597	/			
8.690	+/-0.010	8.693	/			
30.790	+/-0.010	30.790	/			
52.88	+/-0.030	52.88	/			
62.770	+/-0.010	62.770	/			
74.420	+/-0.010	74.420	/			
75.52	+/-0.030	75.52	/			
0.050	+/-0.010	.045	/			

Measured by:	DL
Date:	16/01/11

Audited by:	DAS 38
Date:	9-89 JAN 13 2016

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	
B	12.05.15	Dimensions updated per Dwg Rev C	KJ	